

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005372**Date Inspected:** 27-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI: Mr. Sun Bo

On this date CALTRANS OSM Quality Assurance (QA) Inspector Mr. Paul Dawson arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

This QA Inspector observed ZPMC welder Mr. Yang Ttianbing, stencil 066439 is using flux cored welding procedure WPS B-T-2232-TC-U5F to make stiffener to baseplate welds on OBG deck plate DP575-001-015. Prior to welding the QA Inspector observed the base material had previously been preheated using electrical heater elements. The QA Inspector observed QC measuring a welding current of approximately 290 amps and 28.0 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Mr. Liu Diaquan, stencil 066401 is using flux cored welding procedure WPS B-T-2232-TC-U5F to make stiffener to baseplate welds on OBG deck plate DP575-001-015. Prior to welding the QA Inspector observed the base material had previously been preheated using electrical heater elements. The QA Inspector observed QC measuring a welding current of approximately 315 amps and 32.5 volts. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

The Chinese New Year Holiday started on January 26 and due to this event many of the ZPMC employees are not working today.

WELDING INSPECTION REPORT

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Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
